

DT8728



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2938-2

Job Sheet 203786



Part No: D2938-2

Job Qty: 6 pcs

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/19

Job Tracking No:

Due Date: 1/13/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	1/13/20		0.22	6.19	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	6 pcs	1/13/20		0.00	0.75	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		
120	QC 2	6 pcs	1/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		

SBL 20/02/15

DJP 20-02-18

DJP 20-02-18



1270 Aberdeen Street
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CANADA
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Container No: S256195



Part: D2938-2

Job No: 203786

Serial No/Batch: S256195

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/15/20

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					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DP 20-02-18
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
QC 8 - 17						
QC 8 - 20						
QC 8 - 25						
QC 8 - 3						
QC 8 - 32	J.C.L. 20-02-19					
QC 8 - 33						
QC 8 - 35						
QC 8 - 39						
QC 8 - 4						
QC 8 - 44						
QC 8 - 45						
QC 8 - 49						
QC 8 - 58						
QC 8 - 8						
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
QC 8 - 57						
QC 8 - 76						
QC 8 - 61						
130 QC 8	6 pcs	1/13/20	0.00 0.00		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SA FEB 18 2020
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	1/13/20	0.00 0.27			

150 Powdercoat - 1 White GI(A)- B4B <i>M285890</i>	6 pcs	1/13/20	0.00 0.24	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	<i>20-02-20</i>
				Powdercoat - 4 - B4B	<i>28 34 089</i>
<i>START: 7:50</i> 160 QC 3	6 pcs	1/13/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	<i>FEB 2 5 2020</i>
				QC 3 - 19	<i>DAS 40 9-89</i>
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	6 pcs	1/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	<i>51395</i>
				Packaging 3 - 5 - B4B	<i>DAS 74 FEB 2 6 2020 9-89</i>
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

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				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	1/13/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (HAAS CNC Vertical Machine) Program part number and batch number. Descriptions: 110 - (Manufacture as per dwg) Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Releas					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-003	Saddle Billet, 7075	6 pcs (1 ea)	100-HAAS 4 Axis	5240 460	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-003	6	28	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD	Work Order: 203786
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.125	0.125	0.125	0.126		
B	0.100	0.140		0.130	0.128	0.126	0.126		
C	0.100	0.140		0.120	0.117	0.118	0.119		
D	0.210	0.230		0.221	0.220	0.220	0.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.313	0.313	0.313	0.313		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.120	0.120	0.119	0.120		
O	0.540	0.560		0.548	0.550	0.549	0.548		
P	0.490	0.510		0.501	0.502	0.502	0.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.745	2.745		
S	0.240	0.270		0.251	0.250	0.250	0.248		
T	0.100	0.180		0.136	0.135	0.137	0.137		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DJP
Date: 20-02-18

Audited by: J.C.L.
Date: 20-02-19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 203786
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	4	By	Date
A	0.100	0.140		0.125	0.126				
B	0.100	0.140		0.127	0.126				
C	0.100	0.140		0.118	0.118				
D	0.210	0.230		0.219	0.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.511	0.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.258	0.258				
L	0.312	0.317		0.313	0.313				
M	0.235	0.240		0.238	0.238				
N	0.100	0.140		0.119	0.119				
O	0.540	0.560		0.549	0.547				
P	0.490	0.510		0.502	0.501				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.745	2.745				
S	0.240	0.270		0.249	0.249				
T	0.100	0.180		0.138	0.137				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.316	0.316				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585		1.575	1.575				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: 
Date: 20-02-18

Audited by: J.C.C.
Date: 20-02-18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM 	